



Dart Aerospace Ltd.
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D3068-3
Job Sheet 210513



Part No: D3068-3

Job Qty: 4 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Job Created: 6/10/20

Job Tracking No:

Due Date: 6/15/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3068 REV.A1 IPP RevA: New issue U/R DD verified by:EC

Ship Via:

POSITIVE RECALL

EFFECTIVE 20/06/11 AUTH SAZ

RELEASED 15 DATE 10-06-15

Priority: Medium

OK to make for
Existing customer

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	4 pcs	6/13/20	6/13/20	0.00	0.27	Waterjet - Flow		on 20/06/11
120	QC 2	4 pcs	6/13/20	6/13/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/06/11
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130 QC 8	4 pcs	6/13/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Small Fab - 2 - B4B	4 pcs	6/15/20	0.00 0.20	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	4 pcs	6/15/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

DAS
JUN 12 2020 40
9-89

DAS
58 JUN 12 2020
9-89

					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JUN 15 2020 DAS 40 9-89
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
160 Packaging 3-1 - Stock - B4B	4 pcs	6/15/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B	DAS 28 9-89	
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
170 QC 21 - SA	4 pcs	6/15/20	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70	JUN 16 2020 DAS 77 9-89	
				QC 21 - SA - 9		
Part Op 110 - 1-Cut as per DWG. DWG. Rev: <u>A1</u> PROG. Rev: <u>A1</u> 2-Deburr if necessary						
Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB						
130 - QC8- Inspect parts - second check						
140 - C'SINK HOLES AS PER DWG						
150 - QC5- Inspect part completeness to step on W/O						
160 - ID AND STOCK						
170 - QC21- Final Inspection - Work Order Release						

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MDELRINS0.125	Black Delrin Sheet .125	.0960 sf (.024 ea)	110-Waterjet - Flow - 1	S253969	

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Flow - 1	MDELRINS0.125	0	20	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	1.720Inches ± 0.030	1.750 1.690	1.725	
2	Spacer	0.860Inches ± 0.030	0.890 0.830	.853	
3	Spacer	0.250Inches ± 0.005	0.255 0.245	.251	
4	Spacer	1.480Inches ± 0.005	1.485 1.475	1.486	
5	Spacer	1.980Inches ± 0.030	2.010 1.950	1.987	
6	Spacer	0.098Inches + 0.005 - 0.000	0.103 0.098	100	Diameter
7	Spacer	0.188Inches ± 0.005	0.193 0.183	.188	Diameter
8	Spacer	100.000Degrees ± 0.000	100.000 100.000	100.000	
9	Spacer	0.130Inches ± 0.010	0.140 0.120	.126	Radius

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

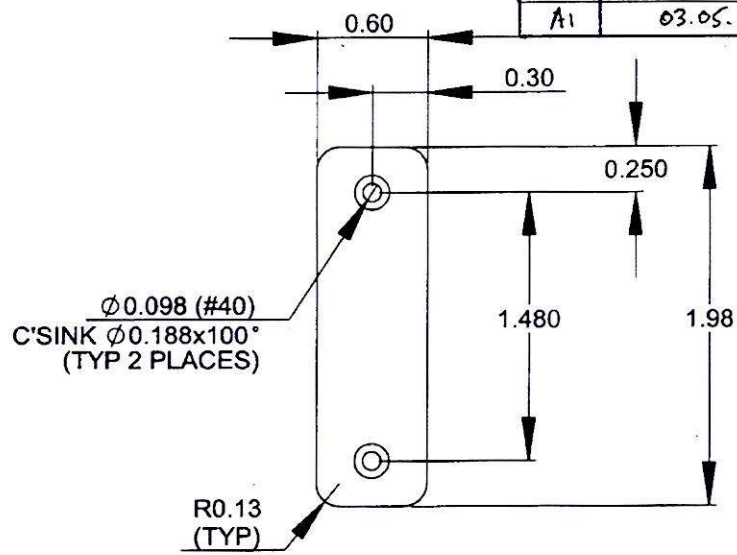
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

RELEASED
02.09.20

DART

COPY ISSUED

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3068	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE SPACER	SCALE 1:1
A	02.09.11	NEW ISSUE	
A1	03.05.15	ADD M-DELIN-S PER NCR 700	

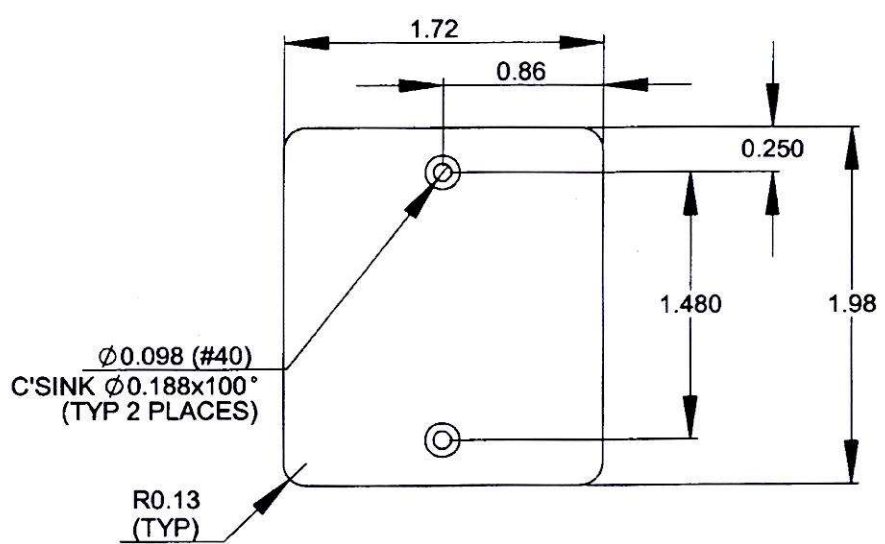


UNDER REVIEW

03.06.15

D3068-1 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S
0.125 THICK
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



OBSOLETE

SUPERCEDED BY

AS 14.07.28

OK TO MAKE
3AD
20/06/11

D3068-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S
0.125 THICK
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Container No: S282528



Part: D3068-3

Job No: 210513

Serial No/Batch: S282528

Revision: A1

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/11/20